

Date: Monday, 6/5/2006 11:01:46 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG
 Job Number : 27419
 Estimate Number : 11018
 P.O. Number : NIA Part Number : D27311
 This Issue : 6/5/2006 S.O. No. : NIA Drawing Number : D2731 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : NIA Type : MACHINED PARTS Drawing Revision : B
 Previous Run : NIA Material : NIA
 Written By : Due Date : 7/10/2006 Qty: 50 U/m: Each
 Checked & Approved By : *[Signature]* 06.06.05
 Comment : Est:D 00.05.19 Added inspect level 8, removed P/O for powder coating EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total : 3.5858 f(s)

D2423 Lug Extrusion

Batch: *23779*

J-F 06/06/17

(52)

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut D2423 Extrusion: 0.82" Long

J-F. 06/06/17

(52)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1

RG



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio D2731-1

Check for crack while loading into the machine

Tumble Deburr any rough edges after tumbling

P/O 1521 C206120104

(52)

MF. 06-08-28

(52)

4.0 *RG* INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Receive + Inspect for transit

damage

AL 06/02/09

(52)

SECOND CHECK



Comment: SECOND CHECK

Inspect level 21

06-08-14 (52)

5.1 - deburr as necessary


- Tumble.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____

NOTE: Date & initial all entries

NCR: Yes ☒ No ☐ DQA:  Date: 06/09/01
QA: N/C Closed: _____ Date: _____

Date: Monday, 6/5/2006 11:01:47 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 27419

Part Number: D27311

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

AL 06/08/29 (52)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/08/31 (52)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06/08/31 (52)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5147

DL 06/08/31 (52)
B 06/08/31 (52)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/09/01 (52)

Job Completion



U 06/09/01

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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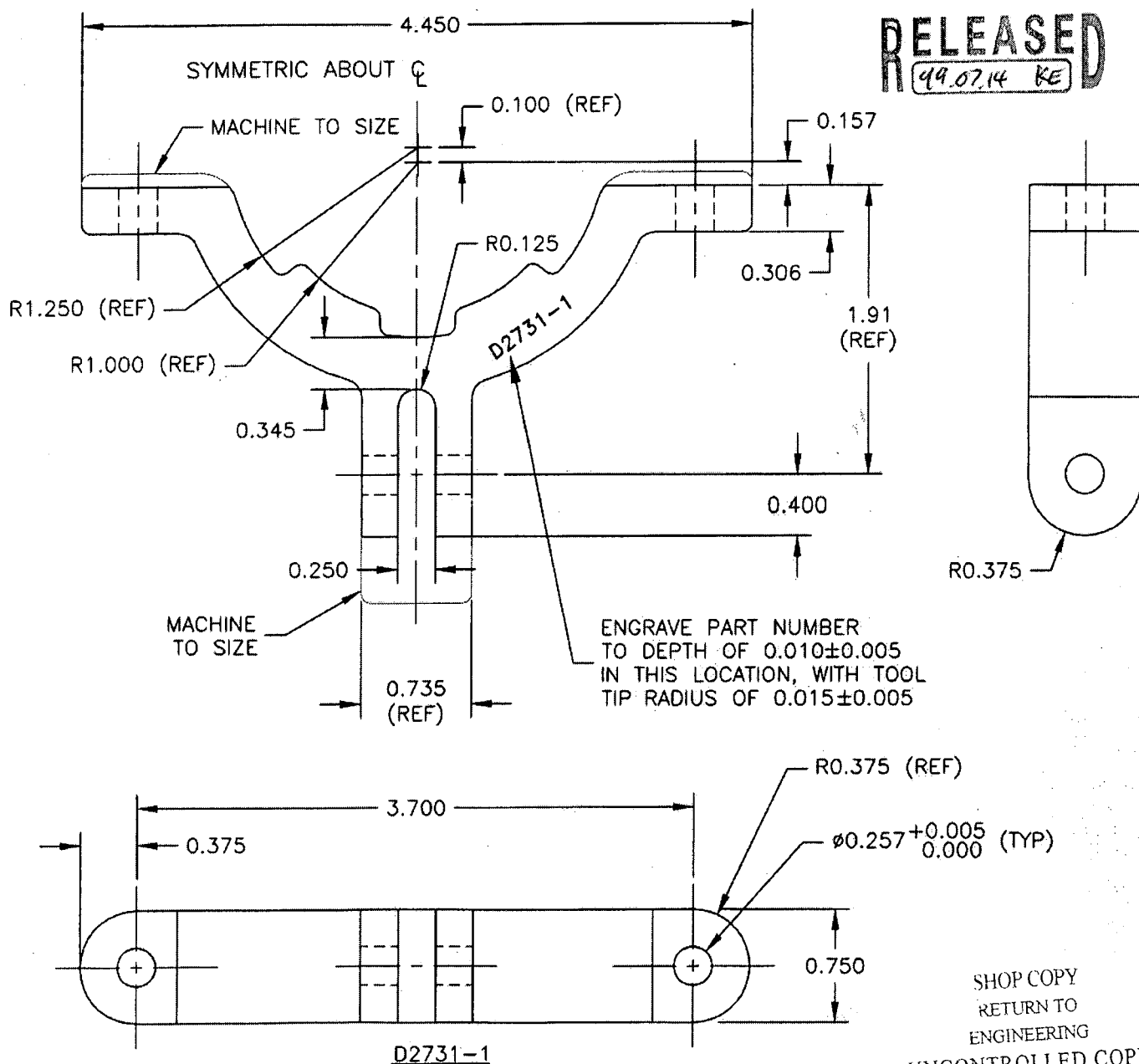
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 1 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1
A	98.05.13	NEW ISSUE	
B	99.07.06	REVISED DIMENSIONS	



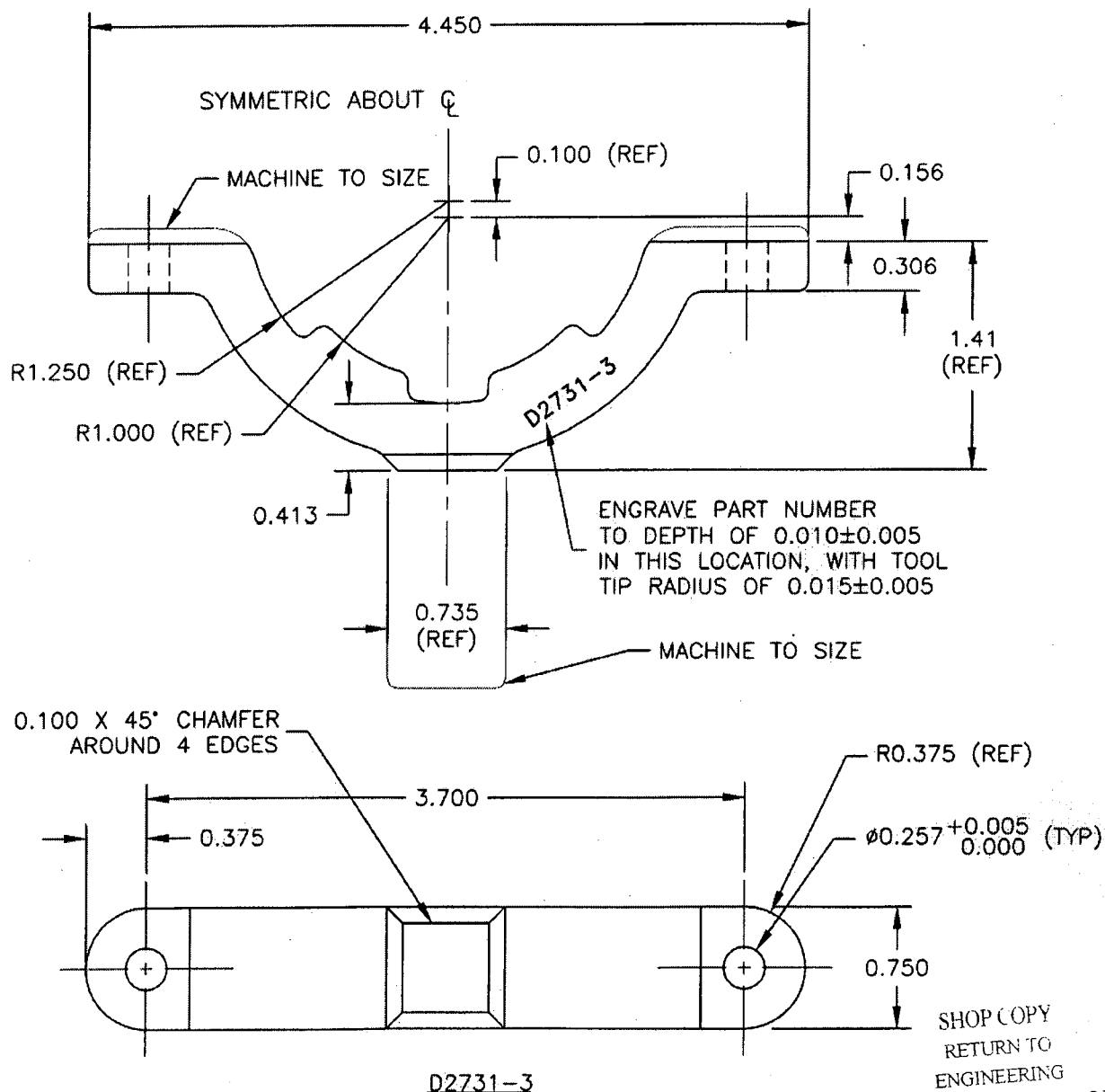
MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 27419



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CHECKED KE	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 2 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
19.07.14 **KE**



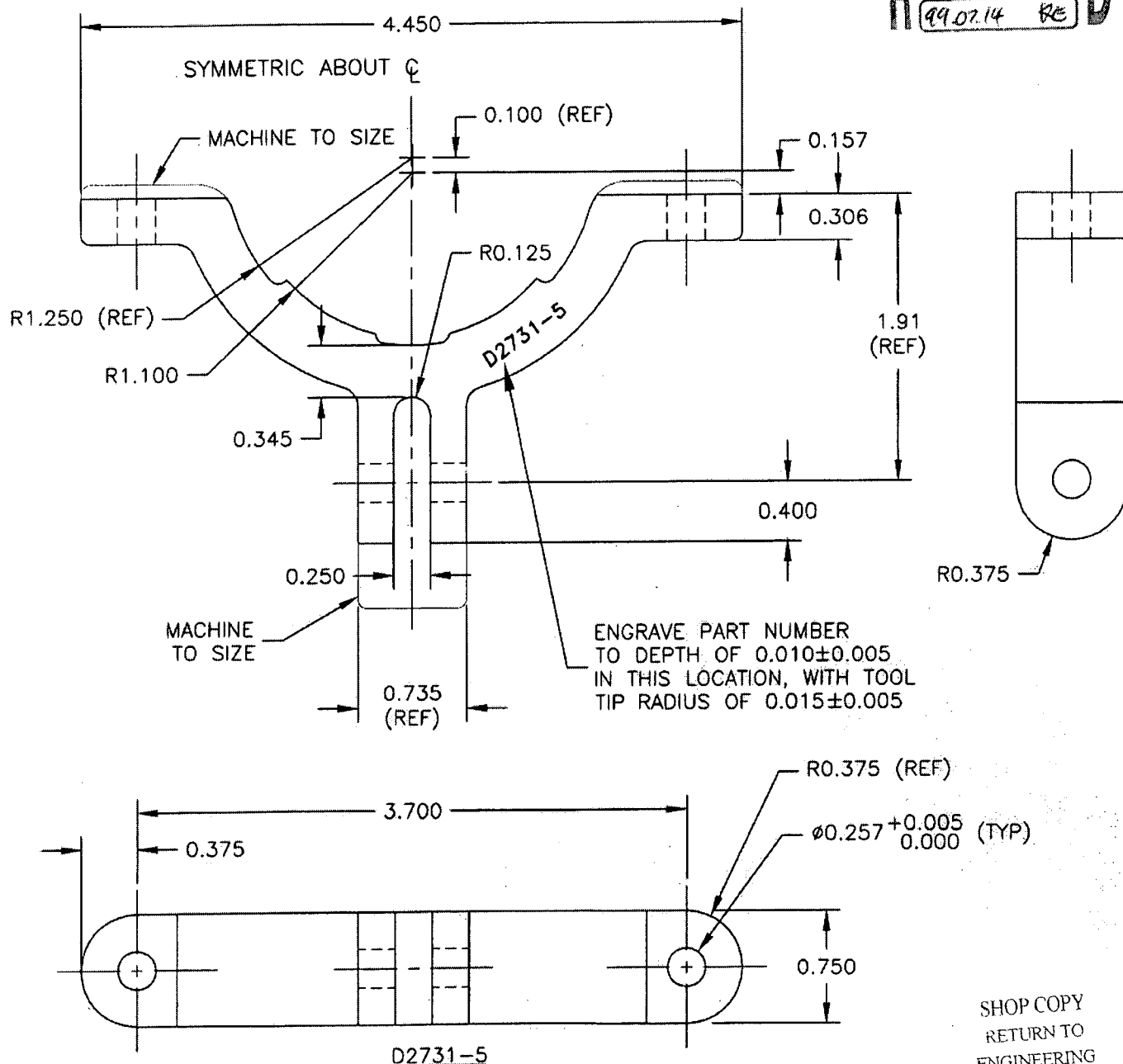
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CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2731	REV. B SHEET 3 OF 4
DATE 99.07.06	TITLE MOUNTING LUG		SCALE 1:1

RELEASED
99.07.14 *RE*

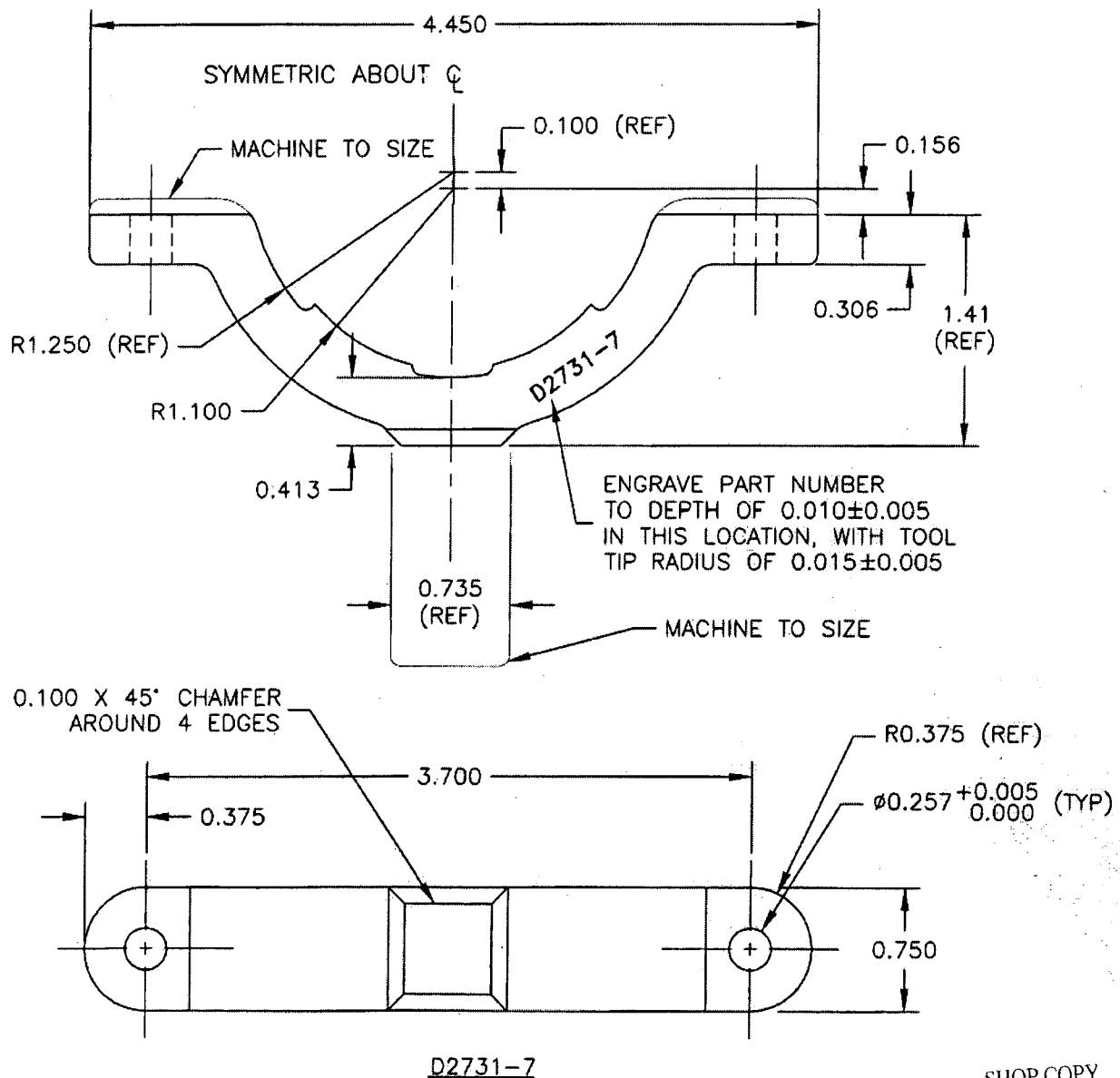


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DART

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CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2731	REV. B SHEET 4 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.07.14 *KE*

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CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

52

D 2731-1

Mounting Lug

1521 ✓

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi (Regula) Walz

Vankleek Hill, August 8, 2006

